

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015148**Date Inspected:** 24-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG Segment 11CE, weld No. OBE11E-052/053. The welder is identified as #044772. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

SMAW in the 2G position for the OBG Segment 11CE, weld No. CA88A-003. The welder is identified as #051359. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13BE side Plate to stiffener, weld No. SP3062-001-0415~028. The welders are identified as #044830/044795. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

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# WELDING INSPECTION REPORT

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Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW bottom Plate, weld No. BP3074-001-001. The welder is identified as #045265. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as segment 10CW repair joints.

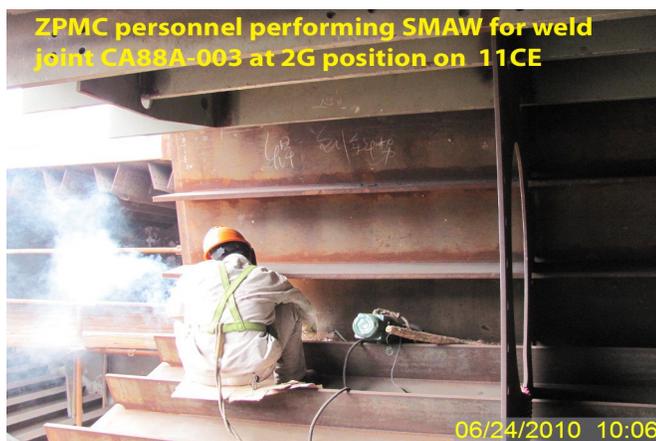
The weld designation reviewed is as follows:

SSD22-PP92.5-174,175

During the Quality Assurance Ultrasonic Testing (UT) review of repaired weld located on Orthotropic Box Girder (OBG) Suspender Bracket SB60E, this Quality Assurance Inspector (QA) discovered the following issues that One (1) longitudinal class "A" indication measuring approximately 15mm in length. The indication dbS rating is a +9. Material thickness is 20mm. The depth of the indication is approximately 12mm. The weld is identified as SB015-060-019. The weld is Complete Joint Penetration (CJP) "T" joint. The joint joining between X53A to X53B. The weld is designated as Non Seismic Performance Critical Material (Non SPCM).

The QA Inspector did not generate any incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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